

Work Order ID 57552

April 8, 2010 9:54:51 AM



Page 1

Item ID: D3594-5	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Door Doubler				
Start Date: 4/08/10	Start Qty: 12.00		Cust Item ID:	
Required Date: 4/16/10	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3594	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
6061-080	1-Cut as per Dwg D3594 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								
	= 7 Deburr mark 10/04/13. 13X. (13)								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

10-4-13

10-4-13

8/10/04/14

(12) (4)

P10-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3594-5 PAR #: _____ Fault Category: Small Prob / W. Jet NCR: Yes No DQA: / Date: 10/04/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: 57552		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/14	100	Found Qty 1 part that has the "detritus" hole pattern off location by 0.050". RL Part moved Drawing 100 <u>waterjetting</u>	<u>/</u> 10/04/14	→ Scrap & Destroy Qty 1 no replace extra was made	<u>10-4-14</u>	<u>S</u> 10/04/14	<u>/</u> 10/04/14	<u>S</u> 10/04/14

NOTE: Date & initial all entries

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Item ID: D3594-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler

Start Date: 4/08/10 Start Qty: 12.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-C'SINK AS [PER dwg d3594								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

85.0/04/16 (12)

8.0/04/16

(X12)

22 => 24 10/04/19

X12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3594-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler

Start Date: 4/08/10 Start Qty: 12.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 10-4-19

170

Identify as per dwg & Stock Location: 237A

0.00



Packaging

Memo

0.00

Packaging

PC 10/4/20 12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/20 MF
10-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57552



Parent Item: D3594-5



Parent Item Name: Door Doubler

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev :A New Issue 08.07.07 EC verified by DD

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

51.0000

0.6947

176



1810-4-13

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT21

51

113438

51

113438

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

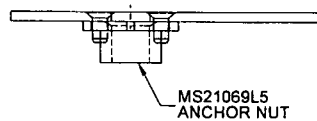
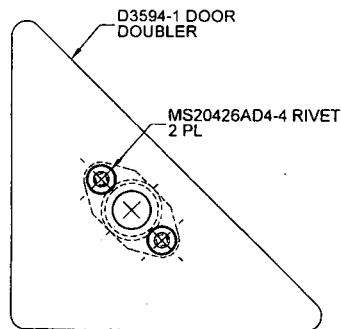
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



4 D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:

1) MATERIAL: -1 & -5

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER

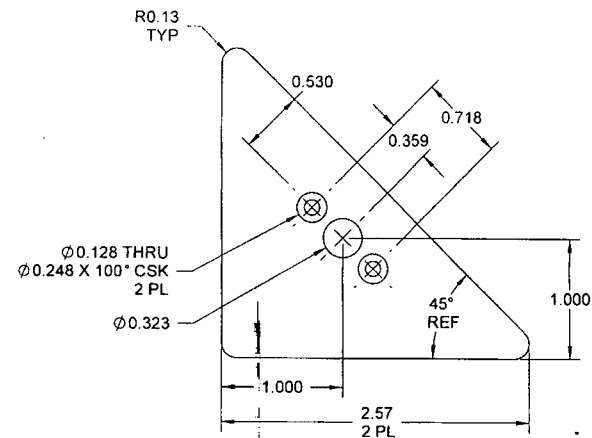
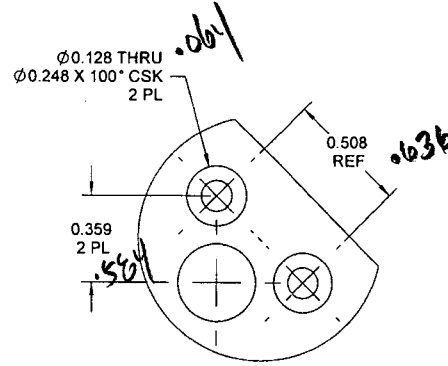
5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

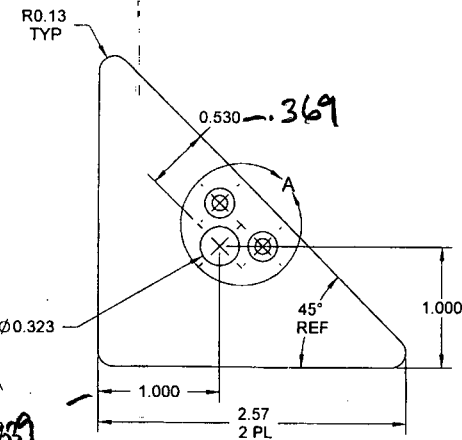
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) WEIGHT -041: 0.04 lbs

-5: 0.03 lbs







D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

RELEASED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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